

Work Order ID 81484

March-14-12 4:21:00 PM

Ship April 2 or sooner
81484

Page 1

Item ID: D350-578-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 14/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/03/14

Tooling:

Date:

Run Start *NR1*

QC: Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9539

B

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D350-578-013 and DSI9539
CHG001

8.7/3/28

MLJ 12-3-28
(6)

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

(E) JB

12/03/28
(6)

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

8.7/3/28

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item Name: Bearpaw

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Required Date: 02/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00

120

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-013 and DSI9539

Location:

PPP Rev: A

130

0.00

130




QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

12/3/28  12/3/29 MF
12-03-29

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81484

D350-578-013

Required Date: 02/04/2012

Required Qty: 6.00

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182B050 *D2182B050* Clamp Cushion Black		Manufactured	No			105	Each	18.0000	6	36			
									**	73932	J B		
<u>Location</u>						<u>Loc Qty</u>		<u>Loc Code</u>					
ST402						18							
79824						18							
D2274 *D2274* Radius Block		Manufactured	No			105	Each	75.0000	12	72			
									**	78233	J B		
<u>Location</u>						<u>Loc Qty</u>		<u>Loc Code</u>					
ST007						75							
72121						32							
78589						43							
D2529 *D2529* Washer		Manufactured	No			105	Each	297.0000	12	72			
									**	29x81873	J B		
<u>Location</u>						<u>Loc Qty</u>		<u>Loc Code</u>					
ST010						297							
66953						2							
79221						155							
79485						140		43x79485					

12/03/28

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Picklist Print

March-14-12 4:21:04 PM

Page 2

Work Order ID: 81484

81484

Parent Item: D350-578-013

D350-578-013

Parent Item Name: Bearpaw

Start Date: 14/03/2012

Required Date: 02/04/2012

Start Qty: 6.00

Required Qty: 6.00

D2438

Manufactured No

105 Each

50.0000

6 36 ✓

D2438

Clamp

**

81484 JB

SP

Location

Loc Qty

Loc Code

ST456

50

77038

6

78594

44

Manufactured No

105 Each

0.0000

12 12 ✓

D4297-1

D4297-1

Bearpaw

AN4-17A

Purchased No

105 Each

598.0000

12 72 ✓

AN4-17A

Bolt

**

JB

SP

Location

Loc Qty

Loc Code

ST358

24

112314

8

116419

16

116704

0

ST359

574

118983

300

120187

74

121011

200

Purchased No

105 Each

374.0000

12 72 ✓

AN4-20A

AN4-20A

Bolt

**

JB

SP

Location

Loc Qty

Loc Code

GA

50

116419

50

ST359

324

117514

51

118983

73

119127

200

118983

March-14-12 4:21:04 PM

Shop Packet Print

12/03/28
Page 2

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Page 3

Work Order ID: 81484

81484

Parent Item: D350-578-013

D350-578-013

Parent Item Name: Bearpaw

Start Date: 14/03/2012

Required Date: 02/04/2012

Start Qty: 6.00

Required Qty: 6.00

NAS1149D0463J

Purchased

No

105

Each

3,048.000

[12] 72

**

NAS1149D0463.J

Washer

Location

Loc Qty

Loc Code

ST297

2000

121011

2000

121011

ST298

1048

116805

0

118384

25

119097

169

120644

854

MS21042L4

Purchased

No

105

Each

5,585.000

[12] 72

**

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

5585

117441

51

117601

157

117885

16

118451

133

119017

232

119075

2996

121011

2000

119075

March-14-12 4:21:04 PM

Shop Packet Print

12/03/28

Page 3

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-578 REV. F OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-578 REV. 1 OR EARLIER

REF. TCCA STC: SH93-4
REF. FAA STC: SR00028NY
REF. FAA STC: SR00029NY
REF. EASA STC: 10016984

1.0 PURPOSE

The purpose of this DSI is to add the D350-578-013 Bearpaw Kit, which is similar to the existing D350-578-011 Bearpaw Kit, except that the machined pockets have been removed per customer preference. The D350-578-013 Kit installs in the same way as the D350-578-011 Kit.

2.0 INSTALLATION PROCEDURE

- 2.1 Jack up the aircraft. Ensure the skid tubes are serviceable.
- 2.2 If the Bearpaws are being installed on Dart Skid tubes remove the D3537-1 or D2648-1 Wearpads prior to installing the bearpaws. It is not necessary to remove the Dart Wearplates and gaskets. Re-install attachment hardware into open inserts.
- 2.3 Position the D4297-1 Bearpaw on the aft end of each skid tube as shown in Figure 2.
- 2.4 Install the D2438 clamps with the hardware as shown in Figure 3.
Caution: The torque on the nuts should be limited to 20 in-lb (2.3 Nm).
- 2.5 The D4297-1 Bearpaw may be relieved to clear wearshoe mounting screws provided the relief leaves 0.375" (9.53mm) thickness.
- 2.6 Lower the aircraft.

3.0 WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D350-578-013 Bearpaw Kit	17.60 lb 8.00 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	157.0 in 3.99 m	2763.2 in-lb 31.92 m-kg

4.0 PARTS LIST

QTY. -013	PART NUMBER	DESCRIPTION
X	D350-578-013	Bearpaw Kit
6	D2182B050	Rubber Cushion
12	D2274	Radius Block
12	D2529	Washer
6	D2438	Clamp
2	D4297-1	Bearpaw
12	AN4-17A	Bolt
12	AN4-20A	Bolt
12	NAS1149D0463J	Washer
12	MS21042L4	Nut or (MS21042-4)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81484 MCT
12/03/14

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 11.02.25
CERT. NO.: SH93-4
ISSUE NO.: 8

B	ADD AN4-20A	RF	11.02.25
A	NEW ISSUE	RF	10.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9539	SHEET 1 OF 3
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	BEARPAW KIT	NTS
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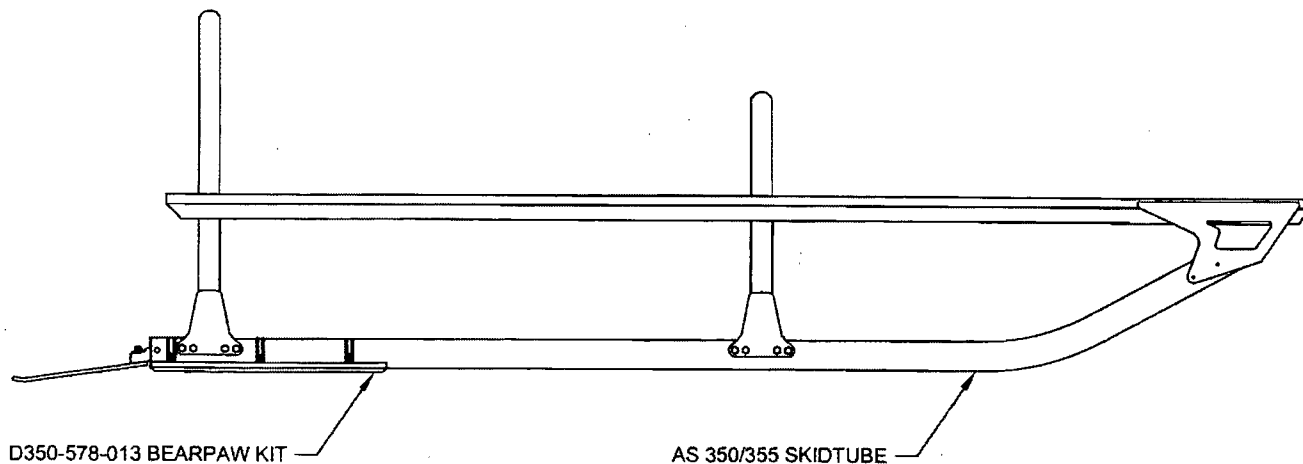


Figure 1. D350-578-013 Bearpaw Kit

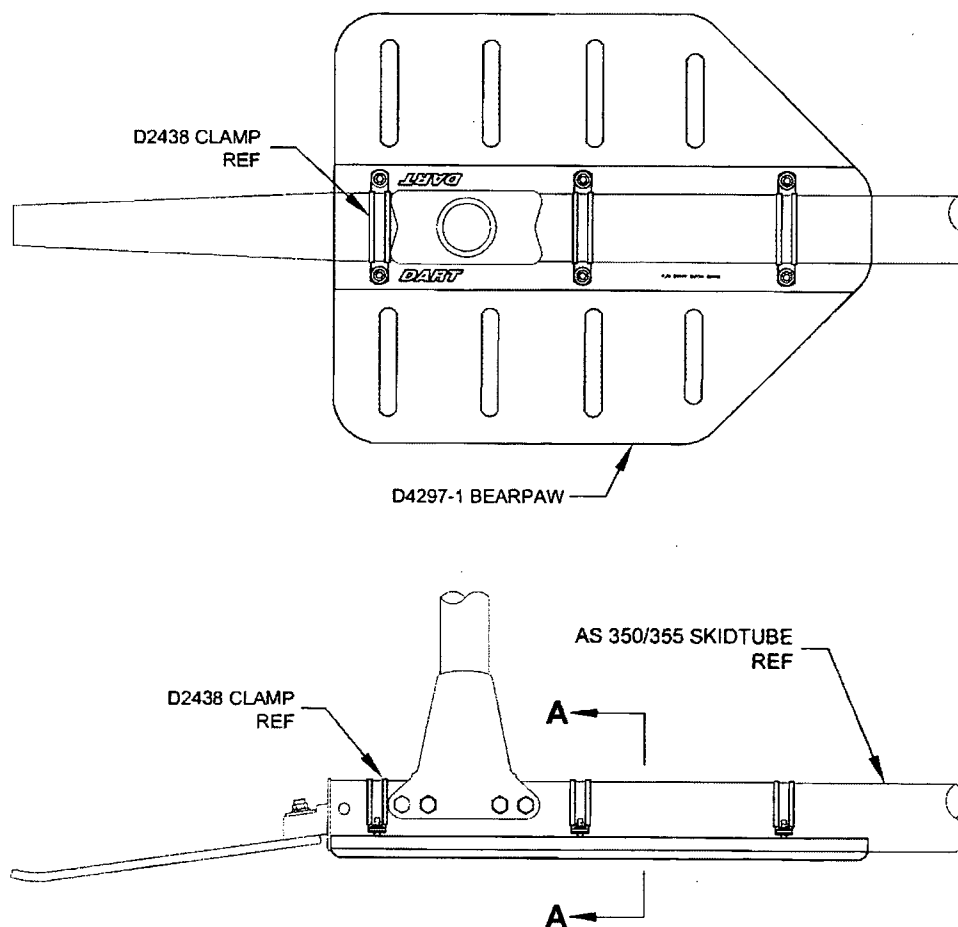


Figure 2. Bearpaw Location (Side View & top View)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.02.25
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9539	SHEET 2 OF 3
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DE APPR.	<i>[Signature]</i>	BEARPAW KIT	NTS
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611284

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

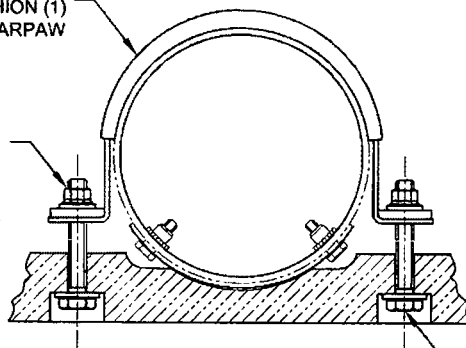
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NOTE: Date & initial all entries

D2438 CLAMP (1)
D2182B050 RUBBER CUSHION (1)
3 PL PER BEARPAW

MS21042L4 NUT (1)
AN960JD416 WASHER (1)
D2274 RADIUS BLOCK (1)
D2529 WASHER (1)
AN4-17A BOLT (1)
OR AN4-20A BOLT (1)
6 PL PER BEARPAW



ADDITIONAL AN960JD416 WASHERS MAY
BE INSTALLED UNDER THE NUTS TO
ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS.
ALTHOUGH NOT GENERALLY NECESSARY,
IT IS ALSO ACCEPTABLE TO REPLACE THE
AN4 BOLTS PROVIDED WITH LONGER OR
SHORTER AN4 BOLTS, IF REQUIRED.

Figure 3. Clamping Detail (Section A-A)

12/2/18

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
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Dart Aerospace Ltd

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-578 REV. F OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-578 REV. 1 OR EARLIER

REF. TCCA STC: SH93-4
REF. FAA STC: SR00028NY
REF. FAA STC: SR00029NY
REF. EASA STC: 10016984

REFERENCE ONLY

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

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12	MS21042L4	Nut or (MS21042-4)

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DAO # 01-O-01

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